

Work Order ID 63953

Monday, November 22, 2010 9:15:38 AM



Page 1

Item ID: D117-762-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 11/22/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/29/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10/11/22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3582

Rev A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D117-762-041 CHG001

OK for BG 11/01/03

120

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend tube as per program D3582 on CNC Bender and Dwg D3582. Folio 3,
use bending aid DT9632
2- cut fwd end of tube as per dwg

DP 10-12-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut Aft end using DT8185

2-Deburr ends

3-Drill Aft Cap holes using DT8678 ***DO NOT OPEN AFT CAP HOLE***

4-Locate DT 8973 & Drill Ground wire hole on top of Tube.

5-Install 3/16 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill.

6-Drill pilot holes for wearplates using DT8974

7-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582.

8- open ground wear holes to 0.391" as per section B-B

9-Open Aft Cap holes using .209" drill.

10-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size.

1 0 BE 10/2/02

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Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Weld fwd cap D2964 per dwg D3582 and QSI 004

A/R AL ROD

Batch:

2-Grind flush

M111365 / M115778

1 0 BE 10/12/02

150

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

81012/03

160

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

81012/03

to

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10-12-6

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BE10/12/07

W/O:		WORK ORDER CHANGES					
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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Open X-Bolt holes to finish size as per Dwg D3582, all sections								
	2-Counter Sink X-BOLT holes as per Dwg D3582								
	3-Deburr and blow out chips from inside of tube, prep. tube for welding.								
	4-Bond web as per Dwg D3582 & QSI 015								
	A/R 241 Sike Flex Batch: <u>M116040</u>								
	Exp Date: <u>11-9-30</u>								
	5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B.								
	A/R AL ROD Batch: <u>M111385</u>								
	6-Grind welds flush								
200	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									

DP 10-12-7
BE 10/12/08
BE 11/12/08

81012103

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		81012/13		Ⓟ			
215 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo ✓ Touch-up alodine as per QSI	0.00 0.00		⇒ ll 10/12/13		①	Ⓟ		
220 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME 7:40 OVEN TEMPERATURE: 320° FINISH TIME: 8:10	0.00 0.00				1		BR 10-12-14.	

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		10112114		1	0		
240  HandFinish Hand Finishing	HandFinishing Memo Install Wearplate & Ground Wire inserts as per Dwg D3582.	0.00 0.00		=> 10112111		1	0		

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Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250



HandFinish

Hand Finishing

HandFinishing

Memo

1-Inspect for Foreign objects

2-Install Aft cap as per Dwg D3582, Detail "C"

A/R 241 Sika Flex Batch: 1115114

Exp Date: 1101

3-Install Wearplates as per Dwg D3582,

Note:Install Bolt and washer on Ground Wire inserts on top of tube see

section D-D of dwg D3582

*****Do not install bolts where indicated on Dwg(Note #6)*****

A/R 241 Sika Flex Batch: 1115114

Exp Date: 1101

4-assemble o'ring as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 1115189

5- Wing Walk as per Dwg D3582 and QSI 005 4.4 1115790

260



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D117-762-041

Location:

PPP Rev:

PPC 3951

280

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

Cupps 3

CL 11/01/03
MF

10-12-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Page 1

Monday, November 22, 2010 9:15:44 AM

Work Order ID: 63953

Parent Item: D117-762-041

Parent Item Name: Replacement Skidiube





Start Date: 11/22/2010

Required Date: 11/29/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A ☐ 07.06.11 ☐ New Issue ☐ EC
IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2962-150 		Manufactured	No				Each	95.0000	1	1			
3.540 Outer Tube, Extrut													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				HALL			95						
				28672			22						
				59934			73						
D2964 		Manufactured	No			140	Each	16.0000	1	1			
Cap													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				LG			16						
				14101			16						
D2971 		Manufactured	No			190	Each	24.0000	1	1			
Cross Bolt Spacer													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				LG			24						
				44445			24						
D3584-1 		Manufactured	No			190	Each	0.0000	1	1			
Web													

B64097

①

BE 10/12/02
DP 10-12-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 63953

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 11/22/2010

Required Date: 11/29/2010

Start Qty: 1.00

Required Qty: 1.00

D2973

Manufactured No

190

Each

156.0000

2

2



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

156

14636

156

190

Each

24.0000

1

1

D3662-3

Manufactured No



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

24

44456

24

190

Each

10.0000

3

3

D3662-1

Manufactured No



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

10

55328

10

240

Each

2,077.000

36

36

ALS4-1032-130

Purchased

No



Insert

Location

Loc Qty

Loc Code

PKG11

804

114723

804

ST281

1000

116049

1000

ST282

234

110511

10

115911

224

ST381

39

114654

39

X36

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube

Start Date: 11/22/2010

Required Date: 11/29/2010

Start Qty: 1.00

Required Qty: 1.00

ALS4-428-165

Purchased

No

240

Each

101.0000

2

2



HL 10/12/14

Inserts

Location

Loc Qty

Loc Code

FP

5

6989

5

ST282

96

114172

96

XZ

D2965

Manufactured

No

250

Each

39.0000

1

1



HL 10/12/14

Cap, 105 Skidtube

Location

Loc Qty

Loc Code

FP4

39

52057

39

X1

D3508-3

Manufactured

No

250

Each

10.0000

1

1



HL 10/12/14

Wearplate

Location

Loc Qty

Loc Code

FP

1

38527

1

FP21

9

62882

9

X1

D3508-9

Manufactured

No

250

Each

7.0000

1

1



HL 10/12/14

Wearplate

Location

Loc Qty

Loc Code

FP16

6

62887

6

FP21

1

54580

1

X1

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Start Date: 11/22/2010

Required Date: 11/29/2010

Start Qty: 1.00

Required Qty: 1.00

D3558-3

Manufactured No

250

Each

10.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP

10

42253

1

55468

9

D3558-9

Manufactured No

250

Each

15.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP

15

50928

1

55469

14

D3558-11

Manufactured No

250

Each

12.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP

12

62885

12

D3558-13

Manufactured No

250

Each

32.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP

32

59558

32

W/O:		WORK ORDER CHANGES					
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Parent Item: D117-762-041





Parent Item Name: Replacement Skidtube

Start Date: 11/22/2010

Required Date: 11/29/2010

Start Qty: 1.00

Required Qty: 1.00

D3508-11	Manufactured	No	250	Each	9.0000	1	1
							
Wearplate							
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>		
		FP16		9			
		54644		9			
D3508-13	Manufactured	No	250	Each	14.0000	1	1
							
Wearplate							
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>		
		FP16		14			
		63248		14			
D3492-051	Manufactured	No	250	Each	48.0000	2	2
							
Plug Assembly							
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>		
		FP013		48			
		44633		2			
		55622		46			
D3492-049	Manufactured	No	250	Each	23.0000	2	2
							
Plug Assembly							
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>		
		FP011		23			
		55621		23			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, November 22, 2010 9:15:45 AM

Page 6

Work Order ID: 63953

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtubo



Start Date: 11/22/2010

Required Date: 11/29/2010

Start Qty: 1.00

Required Qty: 1.00

D3492-053 Manufactured No

250

Each

23.0000

6

6



Plug Assembly



10/12/14

Location

Loc Qty

Loc Code

FP

1

54641

1

FP013

22

62886

22

X6

AN960JD10L NAS1149D0332J Purchased

No

250

Each

0.0000

2

2



Washer

X114884



X2 10/12/14

AN3C4A

Purchased

No

250

Each

2,115.000

28

28



10/12/14

BOLT

Location

Loc Qty

Loc Code

ST303

3

115438

3

ST350

2112

115300

42

115589

70

115936

1000

116075

1000

X28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval. Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

Monday, November 22, 2010 9:15:45 AM

Work Order ID: 63953

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtool

Start Date: 11/22/2010

Required Date: 11/29/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No

250

Each

858.0000

2

2



Bolt



10/12/14

Location

Loc Qty

Loc Code

ST350

848

114330

11

115015

13

115371

100

115422

100

115594

282

115835

342

ST351

10

x2

113121

10

AN960JD416L NAS1149D0416J Purchased No

250

Each

186.0000

2

2



Washer



10/12/14

Location

Loc Qty

Loc Code

ST346

186

106785

2

110153

184

x2

AN960C10L NAS1149C0332 Purchased No

250

Each

25.0000

28

28



washer



10/12/14

Location

Loc Qty

Loc Code

ST245

25

107534

25

xx 115 832

x28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, November 22, 2010 9:15:45 AM

Page 8

Work Order ID: 63953

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtool



Start Date: 11/22/2010

Required Date: 11/29/2010

Start Qty: 1.00

Required Qty: 1.00

AN4-4A	Purchased	No	250	Each	176.0000	2	2
Bolt							

Location	Loc Qty	Loc Code
----------	---------	----------

ST356	175	
-------	-----	--

<u>114615</u>	175	
---------------	-----	--

ST361	1	
-------	---	--

<u>111295</u>	1	
---------------	---	--

NAS1611-012	Purchased	No	250	Each	92.0000	6	6
O-RING							

Location	Loc Qty	Loc Code
----------	---------	----------

FP	92	
----	----	--

<u>113845</u>	92	
---------------	----	--

NAS1611-015	Purchased	No	250	Each	98.0000	2	2
O-RING							

Location	Loc Qty	Loc Code
----------	---------	----------

FP	98	
----	----	--

107178	3	
--------	---	--

<u>115101</u>	16	
---------------	----	--

116081	79	
--------	----	--

NAS1611-016	Purchased	No	250	Each	103.0000	2	2
O-RING							

Location	Loc Qty	Loc Code
----------	---------	----------

FP	103	
----	-----	--

<u>107178</u>	3	
---------------	---	--

112492	50	
--------	----	--

113524	50	
--------	----	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

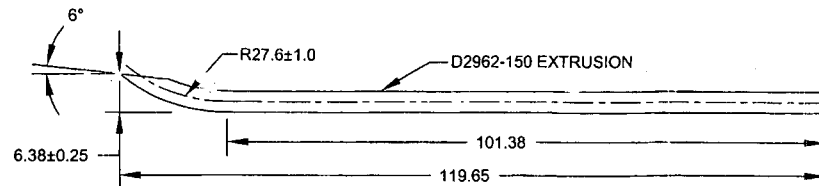
NOTE: Date & initial all entries

PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

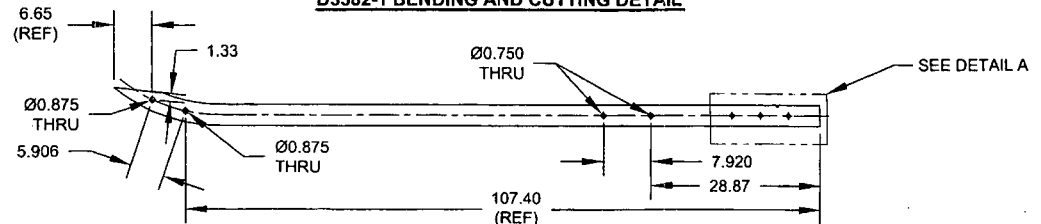
Qty	Part Number	Description
X	D3582-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CROSS BOLT SPACER
2	D3492-049	PLUG ASSEMBLY
2	D3492-051	PLUG ASSEMBLY
6	D3492-053	PLUG ASSEMBLY
1	D3508-3	WEARPLATE
1	D3508-9	WEARPLATE
1	D3508-11	WEARPLATE
1	D3508-13	WEARPLATE
1	D3558-3	GASKET
1	D3558-9	GASKET
1	D3558-11	GASKET
1	D3558-13	GASKET
1	D3584-1	WEB
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AELS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD10L	WASHER
2	AN960JD416L	WASHER

GENERAL NOTES:

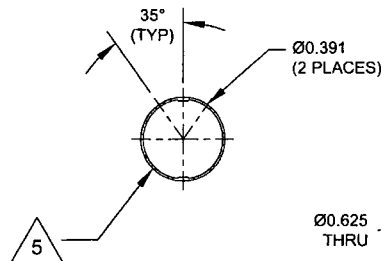
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004.
- INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL Ø0.297 HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
- FINISH:
 - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
 - POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 - ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4.



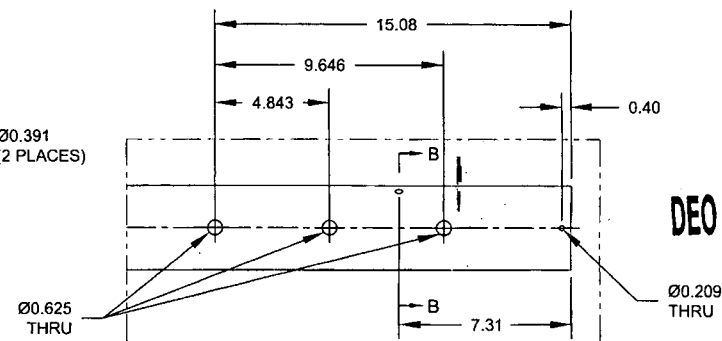
D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B
SCALE 1:5



DETAIL A
SCALE 1:5

DEO ATTACHED

RELEASED
07.11.22

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43953

REV.	DESCRIPTION	PH	DATE
A	NEW ISSUE	PH	07.06.03
DESIGN	DART AEROSPACE USA, INC	BY	DATE
DRAWN	PORT HADLOCK, WA		
CHECKED	DRAWING NO.	REV.	A
MFG. APPR.	D3582		SHEET 1 OF 2
APPROVED	TITLE		SCALE
DE APPR.	BK 117 SKIDTUBE ASSEMBLY		1:20
DATE	07.06.08		

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03/01/11-22

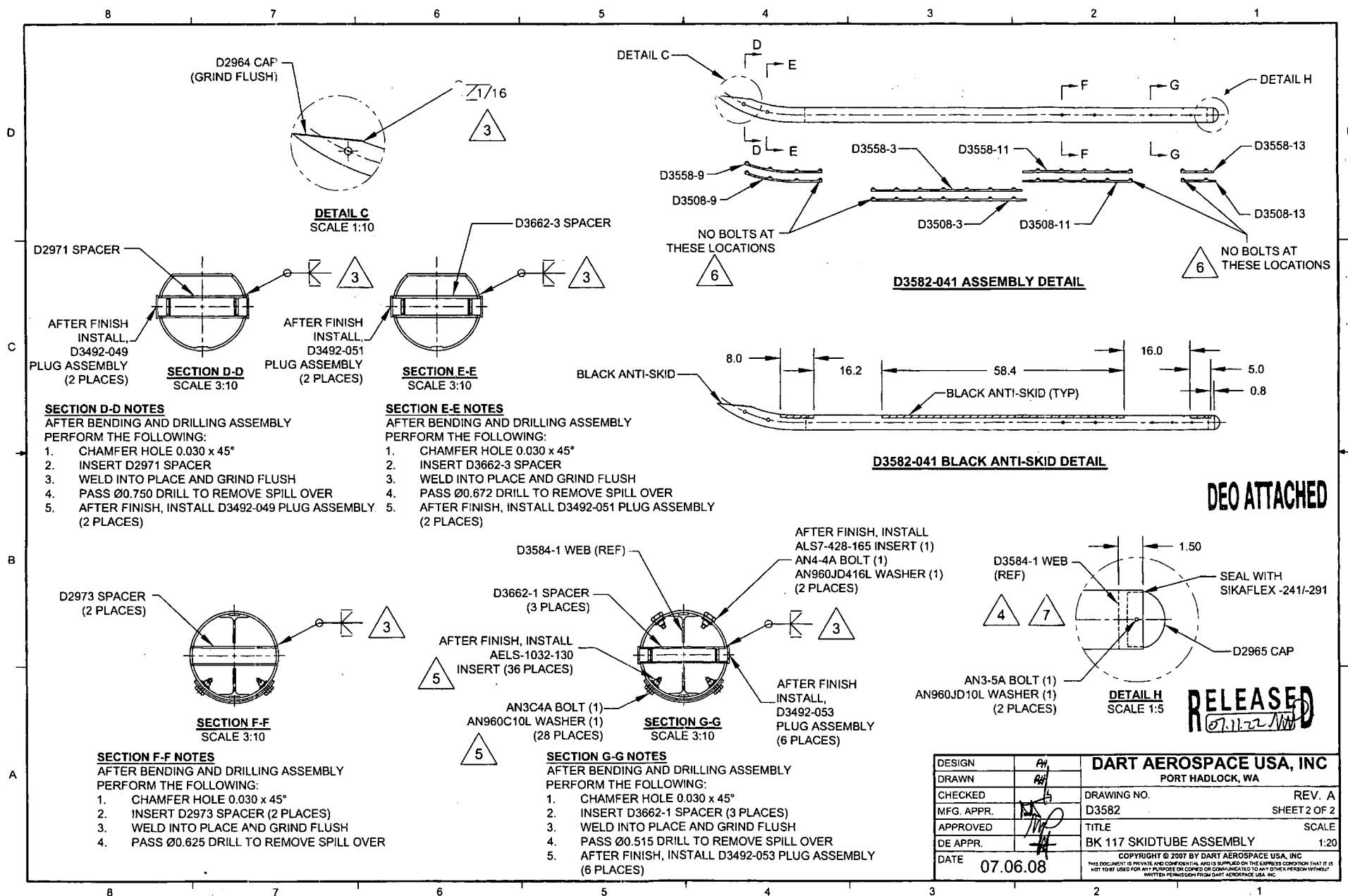
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval. Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



u6 43953

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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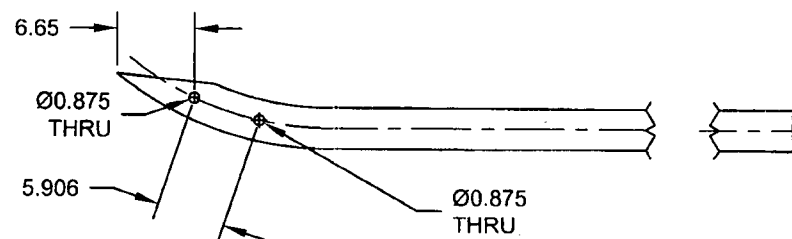
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

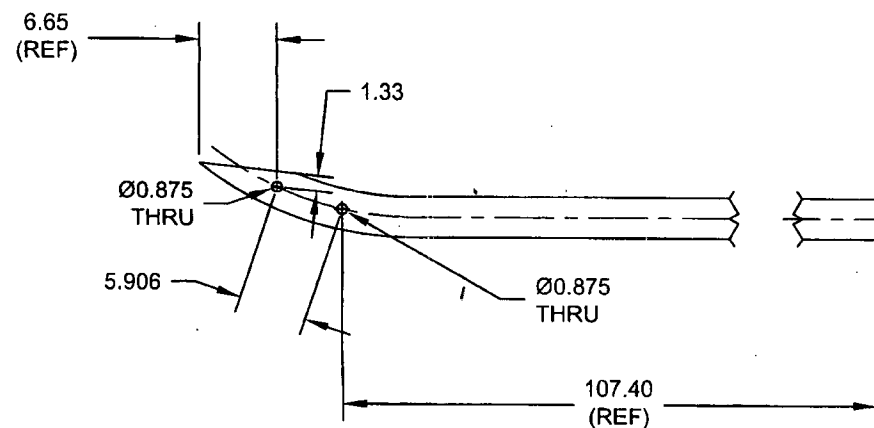
DRAWING NO. D3582	TITLE BK 117 SKIDTUBE ASSEMBLY	REV. A	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3582-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN PH	CHECKED B	MFG. APPR. B	APPROVED MD		DE APPR. MA		
DATE 09.04.06	DATE 04.04.06	DATE 09.04.06	DATE 19/04/06		DATE 09.04.06		

FOR EASE OF MANUFACTURE AND TO ENSURE THE FIT OF BRISTOL WIRESTRIKE SKID GEAR DEFLECTOR:
UPDATE DIMENSIONING OF 2 FWD HOLES ON SHEET 1 AS SHOWN

IS:



WAS:



RELEASED
09/04/22 MD

WLB 68953

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 220

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 54161
Part number: D17-762-041
Description: 17 sk.d tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 09.12.10
Welder Barclay Elliott Date of Test Coupon 09/12/10

The above named individual is qualified in accordance with AWS D17.1.2001 to weld